

SPUT

Dart Aerospace Ltd.

Date: Tuesday, 4/4/2006 1:27:44 PM
User: Kim Johnston

Process Sheet

| | |
|--|------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BRACKET |
| Job Number : 26502 | |
| Estimate Number : 11479 | |
| P.O. Number : N/A | Part Number : D31451 |
| This Issue : 4/4/2006 S.O. No. : N/A | Drawing Number : D3145 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : MACHINED PARTS | Drawing Revision : B |
| Previous Run : N/A | Material : N/A |
| Written By : <u>SPR</u> COMMENT BELOW | Due Date : 4/24/2006 |
| Checked & Approved By : <u>06.04.04</u> | Qty: 10 Um: Each |
| Comment : Est. A 03.02.28 New issue KJ/RF | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------------------|-------------------------|
| 1.0 | M6061T6B2000X02000 | 6061-T6 Bar 2.0" x 2.0" |
|-----|--------------------|-------------------------|



Comment: Qty.: 0.4025 f(s)/Unit Total: 4.0247 f(s)
6061-T6 Bar 2.0" x 2.0"
Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-225/8)
M6061T6B2.000x2.000)
Batch: M17124

ML 06/05/04

10

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|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
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Comment: BAND SAW
Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar

ML 06/05/04

10

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|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1
Machine per Folio FA318 and Dwg D3145
Deburr and Tumble

ML 06/05/04

1

| | | |
|-------|-----|------------------------------|
| 4.0 A | QC2 | INSPECT WORK TO CURRENT STEP |
|-------|-----|------------------------------|



1

Comment: INSPECT WORK TO CURRENT STEP

JL 06/05/04

1

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|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 06/05/04

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 26502

Part Number: D31451

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/05/04

(1)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 06/05/04

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA-11

ml 06/05/04

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/05/04 (1)

Job Completion

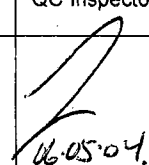


U 06-05-04

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|---|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06/05/04 | 3 | 1 piece scrap engraving too deep, and the wall too thin 1 piece scraps, too marks in the slot. .015" deep, could cause cracking, and will have to thin if marks removed. Marks caused from clamping too tight. | | Scrap: destroy, replace. | | | |  06-05-04 |
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NOTE: Date & initial all entries

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|------------------------------|---------------|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 26502 |
| Description: Bracket | | Part Number: | D3145-1 |
| Inspection Dwg: D3145 | Rev: B | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 0.240 | +/-0.010 | 0.243 | — | | | |
| 0.180 | +/-0.010 | 0.179 | — | | | |
| R0.250 | +/-0.010 | R0.250 | — | | | |
| 1.250 | +/-0.010 | 1.250 | — | | | |
| 1.960 | +/-0.010 | 1.962 | — | | | |
| Ø0.221 x 0.351 | +/-0.010 | Ø0.226 x 0.352 | — | | | |
| 0.108 | +/-0.010 | 0.110 | — | | | |
| 0.125 | +/-0.010 | 0.125 | — | | | |
| 1.636 | +/-0.010 | 1.640 | — | | | |
| R0.188 | +/-0.010 | R0.188 | — | | | |
| 0.125 | +/-0.010 | 0.127 | — | | | |
| 95° | +/-0.5° | 95° | — | | | |
| R0.387 | +/-0.010 | R0.387 | — | | | |
| 0.766 | +/-0.010 | 0.766 | — | | | |
| 0.250 | +/-0.010 | 0.251 | — | | | |
| 1.370 | +/-0.010 | 1.375 | — | | | |
| 0.760 | +/-0.010 | 0.760 | — | | | |
| 4.303 | +/-0.010 | 4.313 | — | | | |
| 0.219 | +/-0.010 | 0.220 | — | | | |
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| Measured by: | JLF |
| Date: | 06/05/04 |

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| Audited by: | J.L |
| Date: | 06/05/04 |

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| Prototype Approval: | N/A |
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 05.02.17 | New Issue | KJ/JLM | |